



TECHNICAL DATA SHEET – REZROK® 155

Revised: 2/2017

DESCRIPTION

RezRok 155 is a high performance epoxy grout used for supporting heavy machinery subjected to dynamic loading. This three component, 100% solids grout meets or exceeds most other epoxy and inorganic grouts in maintaining critical physical properties at elevated temperatures.

PERFORMANCE DATA

COMPRESSIVE STRENGTH (ASTM C-579)	
16 HOURS	11,500 psi
1 DAY	14,500 psi
7 DAYS	17,300 psi
TENSILE STRENGTH (ASTM C-307)	2,600 psi
FLEXURAL STRENGTH (ASTM D-580)	5,300 psi
BOND STRENGTH (ASTM C-882)	Concrete Failure
BOND STRENGTH (ASTM D-4541)	Cohesive Failure
COMPRESSIVE CREEP, INCHES (ASTM C-480)	
<i>10 days cure @ 85°F, 12 hours @ 150°F • Constant load of 350 psi applied at 150°F for 48 hour test period</i>	
10 MINUTES	
30 MINUTES	0.00033
60 MINUTES	0.00047
120 MINUTES	0.00070
480 MINUTES	0.00073
2280 MINUTES	0.00153
1 WEEK	0.00189
1 YEAR	0.00286
10 YEARS	0.00341
VISCOSITY, @77°F	Flowable Grout
VOC	0.00 lb/gal; 0.00 gm/L
VOLUME SOLIDS	100%

BENEFITS

- Outstanding dimensional stability
- Maintains physical properties at elevated operating temperatures up to 180°F, a point at which many other grouts fail
- Contains no volatile solvents
- Fast curing property and high early strengths for shortened downtime and less cost
- Resistant to most corrosive chemicals and oils
- Excellent flowability without aggregate reduction

RECOMMENDED USES

- Grout rails, sole plates and machinery bases supporting equipment subjected to dynamic loads
- Setting equipment, such as:
 - Reciprocating engine compressors
 - Turbines
 - Presses
 - Crushers
 - Centrifuges
 - Steel mill production equipment, such as roller tables

GENERIC DESCRIPTION: Epoxy

STANDARD COLORS: Gray

PACKAGING:

- 2-Cubic Foot (ft³) Unit, consisting of:
- 1 pail of resin
 - 1 can of hardener
 - 4 bags of aggregate (F-1 Powder)

COVERAGE: 2 Cubic Feet (ft³)

REZROK® 155
HIGH STRENGTH MACHINERY GROUT

STORAGE & INSTALLATION

STORAGE ENVIRONMENT	Dry area, 65-80°F
APPLICATION TEMPERATURE, AMBIENT	60-95°F
SHELF LIFE	1 year
INSTALLATION THICKNESS, MAXIMUM PER LIFT	4"
POT LIFE, @ 77°F	40 minutes
INITIAL SET (REMOVE FORMS), @77°F	16-24 hours
FULL SERVICE, @ 77°F	7 days

Material cures more slowly at cooler temperatures, and working time will be substantially reduced at higher temperatures. In hot weather, material should be cooled to 65°F to 80°F prior to mixing and application to improve workability and avoid shortened pot life. The data shown above reflects typical results based on laboratory testing under controlled conditions. Reasonable variations from the data shown above may result.

CONSIDERATIONS & LIMITATIONS

1. Store all grout components (including aggregate) at 65-80°F for at least 24 hours prior to mixing. Do not use aggregate if wet or damp.
2. Do not alter mixing proportions. Use all liquid and all aggregate in unit.
3. Always protect the work area from direct sunlight or inclement weather before, during and after grouting.
4. Grouting and mixing area must be well ventilated.
5. Do not thin with solvents unless advised to do so by ITW Engineered Polymers.
6. Confirm product performance in specific chemical environment prior to use.
7. Prepare substrate according to "Surface Preparation" portion of this document.
8. Always use protective clothing, gloves and goggles consistent with OSHA regulations during use. Avoid eye and skin contact. Do not ingest or inhale. Refer to Material Safety Data Sheet for detailed safety precautions.
9. For industrial/commercial use. Installation by trained personnel only.

SURFACE PREPARATION

CONCRETE: Apply only to clean, dry and sound concrete substrates that are free of all coatings, sealers, curing compounds, oils, greases or any other contaminants.

- New concrete should be cured a minimum of 28 days.
- Concrete that has been contaminated with chemicals or other foreign matter must be neutralized or removed.
- Remove any laitance or weak surface layers.
- Concrete should have a minimum surface tensile strength of at least 300 PSI per ASTM D-4541.
- Surface profile shall be CSP-5 or greater meeting ICRI (International Concrete Repair Institute) standard guideline #03732 for coating concrete, producing a profile equal to 40-grit sandpaper or coarser. Prepare surface by mechanical means to achieve this desired profile.
- Moisture vapor transmission should be 3 pounds or less per 1,000 square feet over a 24 hour time period, as confirmed through a calcium chloride test, as per ASTM E-1907. Quantitative relative humidity (RH) testing, ASTM F-2170, should confirm concrete RH results <75%.
- All surface irregularities, cracks, expansion joints and control joints should be properly addressed prior to application.

Refer to PolySpec Guidelines for Subfloor Preparation for additional details.

INSTALLATION STEPS

NOTE: Refer to "Considerations & Limitations" and "Surface Preparation" portions of this document for important instructions.

1. **PREPARATION:** Mechanically chip out the concrete surfaces to be grouted about 1/2" to expose the largest aggregate. Remove dust by blowing with dry, compressed air.
NOTE: Concrete must be free of oils, waxes and chemicals, and it must be dry.
2. Remove oils from machinery using a degreaser. Metal surfaces to receive grout should be roughened with a grinder prior to grouting.
3. Seal all anchor bolt sleeves with PVC pipe or polyethylene wrapping. Wax all lifting screws, wedges, jack bolts and other supporting items.
4. Build forms up at least one inch above the bottom of the engine frame. Apply paste wax to forms and chamfer strips in two coats. As an alternate method, plastic sheeting may be stapled to the forms; in this case, make sure sheeting is free of wrinkles. Seal forms with caulking material. Forms should be watertight.
NOTE: In some cases, it may be necessary to add steel reinforcement to the grout bed, especially in corner areas. For larger pours, expansion joints are recommended. For more information, consult your ITW Engineered Polymers Technical Representative.
5. **MIXING:** Pour Component A Resin into Component B Hardener pail. Mix thoroughly for at least two minutes using a mechanical jiffy-type mixer operated at low speed. Do not over mix.
NOTE: Do not add water or solvents to any of the components. Do not alter liquid proportions.
6. Pour catalyzed liquid into a concrete mortar mixer.
7. Add Part C Aggregate gradually while mixing at 20 rpm maximum. Mix until all particles are wetted out. Use all of the aggregate unless advised otherwise by a ITW Engineered Polymers Technical Representative.
8. **APPLICATION:** Pour catalyzed grout into forms from one end to the other in the area to be grouted.
NOTE: Depth of pour in one application should not exceed 4 inches. If a total depth of more than 4 inches is required, consult your ITW Engineered Polymers Technical Representative.
9. Final grout level should come slightly above base plates or machinery frame.
10. Smooth grout surface by lightly brushing with a brush dipped in PolySpec® Smoothing Liquid #2. Do not overuse.
11. **Final Procedures:** Always wear gloves when using this product.
12. Forms may be removed after grout has completely cooled.
13. After grout has cured, back off leveling screws, and tighten anchor bolt nuts.
14. Make sure grout area is protected from sudden temperature changes for at least 48 hours after grouting.

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